

Work Order ID 71862

Wednesday, July 13, 2011 11:01:33 AM

Page 1

Item ID: D2022-103

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer

Start Date: 7/14/2011 Start Qty: 40.00

Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-07-13

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2022	Rev ...								

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Note: 323" dia drill

1-Turn as per folio FA207 & dwg

FOLIO REV: N/A

DWG REV: N/A

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/8/15

40 0

40 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 7/14/2011 Start Qty: 40.00

Required Date: 7/28/2011 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

G.A 11/08/15

40

φ

Quality Control

130

Identify as per dwg & Stock Location: S

0.00



Packaging

Memo

0.00

11/8/16 (40) S

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/8/18 J

Quality Control

11-08-16
(40)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 71862

Parent Item: D2022-103

Parent Item Name: Spacer




Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A 11.05.11 new DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750  6061-T6 Round Bar .750"		Purchased	No			100	f	51.4830	0.0189	0.795789			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT013	51.483	
112442	0.796	
116406	0.617	
117481	26.07	
118106	24	

Handwritten signature/initials

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

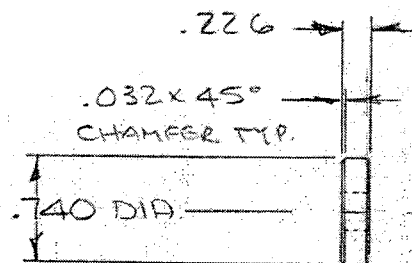
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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RELEASED
1970 19 BW



D2022-101
D2022-103

DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA. IN -103

71862

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)



D2022

D2022-103		SPACER 5/16 ALUM. 6061-T6		QQ-A-250/B
D2022-101		SPACER 1/4 ALUM. 6061-T6		QQ-A-250/B

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS LOANED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523	QTY. REQUIRED	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN		BASIC CODE	DA. DASH NO. W-HEAD NEAR SIDE P-HEAD FAR SIDE	CONTRACT NO. DART AERO ACCESSORIES INC. DATE: 9/20/19 CLIENT:				
APPROVED		D-DIMPLE DASH NO. OF SHEETS C-COORDINATING	L-LENGTH DASH NO. W-WIDTH DASH NO.					
DESCRIPTION OF CHANGE	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES FIN. 3. REMOVE SHARP EDGES .015 MAX. 4. THREADS PER MIL. E. 2742 5. HOLES PER AND 10581	UNITS 1. TOLERANCES - JOE 1.010 2. ANGLES - 30° 3. PARALLELISM 4. ECCENTRICITY 5. STRAIGHTNESS ABOUT 6. ALL MAT. CENTER LINES 6061	BASIC CODES 1. DIMENSION FORD 2. DIMENSION FORD	TITLE: SPACERS DWG. NO. D2022 SCALE 1:1 SHEET 1 OF 1				

REPORT ALL DISCREPANCIES - DO NOT SCALE

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